

Date: Thursday, 23/10/2008 10:54:12 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
<b>Job Number</b> : 42889	
<b>Estimate Number</b> : 12932	
<b>P.O. Number</b> :	<b>Part Number</b> : D29382UP
<b>This Issue</b> : 23/10/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2938 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 41727	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/11/2008 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JLD 08.10.23	
<b>Comment</b> : Est Rev:A New Issue 07-07-04 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D6101003	Saddle Billet, 7075
-----	----------	---------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Issue material from stock: 7075-T7351 (QQ-A-250/12)  
 Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
 (D6101-003) Batch No: B34873

28 08/10/29 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 5-Deburr

DJP 08/10/31 / J.L. 08/11/01

P70

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

28 08/11/07

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------






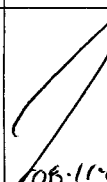
**Comment:** INSPECT ALL DIM TO DIM SHEET

28 08/11/07 / J.L. 08/11/01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2938-2 UP PAR #: J/A Fault Category: Prod - mach NCR: Yes No DQA: A Date: 08-11-13  
 (D206-642-312/-412/514) QA: N/C Closed: tg Date: 08/11/20

NCR: <u>42889</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/01	2	1 part lifted on 4th axis while machining causing deep marks in skid bolt area		- scrap + replace qty 1 <u>B 34873</u>	IL 08/11/01	 08-11-03	 08/11/03	 08-11-03
		r.c. tooling wear						

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:12 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 42889

Part Number: D29382UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/11/07 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.H. 08/11/10

(10X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

J.F.

08-11-10 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 420

8/11/10

(10X)  
S.D.

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12 J.F.

Job Completion



mf 08-11-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42889
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.113	0.113	0.112	0.114		
B	0.100	0.140		0.113	0.115	0.114	0.117		
C	0.100	0.140		0.127	0.126	0.130	0.119		
D	0.210	0.230		0.222	0.222	0.222	0.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.316	.316	.316	.316		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		0.109	0.110	0.110	0.108		
O	0.540	0.560		0.550	0.550	0.550	.548		
P	0.490	0.510		0.501	.503	.501	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.250	0.252	0.252	.253		
T	0.100	0.180		0.130	0.130	0.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.318	0.318	0.318	0.318		
X	1.250	1.270		1.264	1.2625	1.262	1.261		
Y	1.565	1.585		1.577	1.574	1.573	1.571		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JTP / 88  
Date: 08/10/30 / 08/11/07

Audited by: J.F.  
Date: 08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42889
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7*	80		
A	0.100	0.140		.119	.115	.112	.114		
B	0.100	0.140		.114	.111	.108	.113		
C	0.100	0.140		.122	.118	.119	.117		
D	0.210	0.230		0.223	.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.234	.234	.234	.234		
N	0.100	0.140		0.110	.107	.107	.106		
O	0.540	0.560		.551	.545	.541	.550		
P	0.490	0.510		.501	.501	.498	.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.252	.252	.253	.255		
T	0.100	0.180		.130	.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.318	.318	.318	.318		
X	1.250	1.270		1.259	1.257	1.268	1.262		
Y	1.565	1.585		1.567	1.578	1.579	1.572		
Z	0.178	0.198		0.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / 88  
Date: 08/11/01 / 08/11/07

Audited by: J.F.  
Date: 08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description: 206 Saddle, Outboard, Right side</b>	<b>Part Number:</b>	<b>D2938-2</b>
<b>Inspection Dwg: D2938 Rev. C</b>		<b>Page 1 of 1</b>

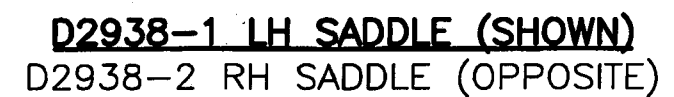
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	13	14		
A	0.100	0.140		.112	.113				
B	0.100	0.140		.108	.108				
C	0.100	0.140		.119	.119				
D	0.210	0.230		.218	.219				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.316	.316				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.105	.105				
O	0.540	0.560		.550	.498				
P	0.490	0.510		.499	.500				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.253	.253				
T	0.100	0.180		.130	.130				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.318	.318				
X	1.250	1.270		1.262	1.264				
Y	1.565	1.585		1.575	1.576				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	08/11/07

Audited by:	JF
Date:	08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



- 10 TO 0.015 DEEP  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 0889

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN <i>A</i>	DRAWN BY <i>CB</i>	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2938 REV. C SHEET 1 OF 1
DATE 06.11.09	TITLE SADDLE OUTSIDE	SCALE 2:3

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

07.02.12

